Wo	rk	Ord	er]	D	10990
Dece	inbe	r-05-1	3 2:	34:03	3 PM

109908

Page 1

December-03-13	2.34.03 PM									
Item ID: Revision ID:	D3447-7	1	Accept	*N900	040	100)* s	Setup Star	*N!	S1*
	Clevis							Stop	*N!	S2*
Start Date:	12/05/13 Start Qty: 10.00	*10*		Cust Item I	D:					
Required Date: Reference:	12/19/13 Req'd Qty: 10.00	*10*		Customer:						
Approvals:	Process Plan: MUS	Date: 13-12-05	Tooling:	Da	nte:	- -	R	Run Star	!/1	R1*
	QC:	_ Date:	SPC (Y/N):	Da	nte:			Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					• • • • • • • • • • • • • • • • • • • •				
D3447	Rev A									
100 * *3¶ ∩∩* Doosan	Hardinge CNC LATHE	SMALL	0.00				lO	Ø		0AS 40 9-80
	Memo		0.00						***************************************	
Doosan I. athe	Turn as per Dwg Rev: _ Folio Rev:_	A								13/12/20
120,	QC2- Inspect parts off n	nachine FAI/FAIB	0.00							OAS 40 40
120 *120 *120*			0.00				10			40 T
Quality Control	Мето		0.00							13/12/20
130	QC8- Inspect parts - sec	ond check	0.00							
130			=	k 13/12/21			10	_0_		
Quality Control	, Memo		0.00	13/12/21						

DQA:		Date:			WORK ORDER NON	_	011501	2000 / 110	D 4 T E			TRACE"
QA Closed:		Date:	:		WORK ORDER NON	-C(ONFOI	RIMANCE / UP		ork Order uj	pdate only	AEROSPACE
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet	Engineering Quality
NCR 1	No				Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root			T	Desc	ription of work order update		Initial	Acti	on	Sign &		
Cause	Date	Step	Qty		or non-conformance	Cr	nief Eng	Descri	ption	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport								·	,			
Unapproved												
						FA	ULT CAT	TEGORY				
Landi	ng Gear Bendir	g Not Conce	entric		General Bend BOM/Route		Folio/F Grain	rogram	F	Outside Dim	 -	Pressure/Forced
	Cracks				Broken/Damage/Defect		Hardwa			Over/Under Part Incorre	ct	Set-up Temperature/Cure
	Crimp/ Cuffs	Kink/Ripple	e/Wave		Burrs Contamination		1	ion Incomplete/Unditions Incomplete/U	-	Part Lost/M Part Moved	· ·	Weld Wrong Stock Pulled
	Crushi	ng			Countersink		Misalig	ned/off center		Positioned \	Wrong	
	Heat T	reat			Cut Too Short		Mislabe	eled		Power Loss/	'Surge	Other
	Inspec	tion Strip ir	1 Tube		Drawing		Misread	d				
	Marks,	'Chatter			Drill Holes		Off-set					
	Turnin	g Sequence	j		Finish		Out of (Calibration				
	Wave/	Twist in Tu	be		Fit/Function		Out of	Sonuence				

DQA:			Date:										Tainae
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		/ork Order uj	ndate only	AEROS PACE
<u> </u>			Dutei										
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
	-					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	۷o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	۷o. ِ					Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Desc	I ription of work order update		nitial	Δct	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	1	ief Eng	i	ription	Date	Verification	QC Inspector
Design								,8					Q ope oco.
Doc/Data													
Equip/Tooling					ļ								
Handling/Pre													
Material						:							
Operator						•							
Offset/Setup							ŀ						
Process				:									
Supplier													
Training				į									
Transport													
Unapproved											,		
							FAI	ULT CAT	TEGORY		· · · · · · · · · · · · · · · · · · ·		
Landi	ng G	Gear				General							
		Bending				Bend		Folio/P	rogram	Ī	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct T	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruct	ions Incomplete/L	Jnclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	<u>۔</u> Vrong	
		Heat Trea	it			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	d	_	_	·	
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of 0	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence				

Work Order ID 10990) 08	109908	er ID	Orde	ork (W
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109908

Page 3

December-05-1	3 2:34:03 PN	1		1 () >	1900						
Item ID: Revision ID:	D3447-7			Accept	*N900	040	100)* s	etup Start	*N	S1*
Item Name:	Clevis								Stop	*N	S2*
Start Date:	12/05/13	Start Qty: 10.00	*10*		Cust Item 1	D:					
Required Date Reference:	: 12/19/13	Req'd Qty: 10.00	*10*		Customer:						
Approvals:	Process Pla	ın:	Date:	Tooling:	D:	ate:	Man	R	tun Start	!/	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description Identify as per dwg & Sto	ck Location: Mezz	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 Packaging Packaging		Memo	<u> </u>	0.00				10x	DAS 28 9-89	<u> </u>	<i>-3</i> 0
180		QC21- Final Inspection -	Work Order Release	0.00							
180		.'		0.00				MC	5 14	-02-	03
QC Quality Control		Memo		0.00							
									1401	-30	

DQA:		Date	e:									
QA Closed:		Date	a :		WORK ORDER NON	-CC	ONFO	RMANCE / UPDAT		ork Order up	ndate only	AEROSPACE
					DISPOSITION			۸۵		PARTMENT		
Work Orde	er:				DISPOSITION			AG		PARTIVIENT/	PROCESS	
					Rework			Skid-tube Cros	sstube		Water Jet	Engineering
Part N	١٥				Scrap			Machining Sma	all Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	noforming Fin	nishing	Rec/Stor	e/Packaging	Other
NCR N	No				Suspected Unapproved			Large Fab Com	nposite		Supplier	
Root			T	Desci	ription of work order update		nitial	Action		Sign &		
Cause	Da	te Step	Qty		or non-conformance	Ch	ief Eng	Description	-	Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre			ŀ									
Material								·				
Operator			ŀ							!		
Offset/Setup												
Process												
Supplier												
Training												
Transport												
Unapproved												
						FA	JLT CA	TEGORY				
Landi	ng Gear				General				-	_		
	Bend	ing			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Cent	re Not Conc	entric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracl	cs			Broken/Damage/Defect	$oxed{oxed}$	Hardwa	ire		Part Incorred	t [Temperature/Cure
	Crim	p/Kink/Ripp	le/Wave		Burrs	L	Inspect	ion Incomplete/Unqualifie	ed	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crusi				Countersink		Misalig	gned/off center		Positioned W	/rong	_
	_	Treat			Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Other
		ection Strip i	n Tube		Drawing		Misread	t				
	Mark	s/Chatter			Drill Holes		Off-set		•			
		ing Sequenc			Finish		Out of (Calibration	•			
	Wave	e/Twist in To	ube		Fit/Function		Out of	Sequence				

December-05-13 2:34:07 PM

Work Order ID: 109908

109908

Parent Item:

D3447-7

D3447-7

Parent Item Name: Clevis

Start Date: 12/05/13

Required Date: 12/19/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A05.08.26New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No	*****		100	f	26.8846	0.4412	5	Α.		Marine San Company and Company
*M6061T6 6061-T6 Round Bar 1.250						**		OA (13/	12/1(

Location Loc Oty Loc Code MAT013 26.8846 -> m126593 26.8846

DQA:			Date:			·							TRACT
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Vork Order uj	odate only	AEROSPACE
Manle Ond						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Orde	er: -	•				Dawe als			ا ماریم اماری	Cuanatula	7	Matar lat	
Part N	NO.					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
	•••					Use-as-is			noforming	Finishing	=	re/Packaging	Other
NCR f	No.					Suspected Unapproved		,,,,,,,,,	Large Fab	Composite		Supplier	
	_			.					I	. •	1 0: 0		
Root		Data	c.	۵.	Desci	ription of work order update	l	nitial		tion · .·	Sign &	., .,	
Cause	\vdash	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design	$\vdash \vdash$												
Doc/Data Equip/Tooling	\vdash		•										
Handling/Pre	H			:				•					
Material	Н												
Operator	H												
Offset/Setup	П												
Process	П												
Supplier													
Training													
Transport													
Unapproved													
							FAI	ULT CA	TEGORY				
Landi	ng G	Gear				General		_		·			
		Bending				Bend	<u></u>	Folio/F	Program	L	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	L	Grain		_	Over/Under	tolerance	Set-up
	\vdash	Cracks			<u> </u>	Broken/Damage/Defect	L	Hardwa	are	L	Part Incorre	ct	Temperature/Cure
	-	Crimp/Kir	nk/Ripple	/Wave		Burrs	<u> </u>	Inspect	ion Incomplete/Ui	nqualified	Part Lost/M	issing	Weld
	\vdash	Cuffs				Contamination	L	1	tions Incomplete/l	Unclear	Part Moved	L	Wrong Stock Pulled
	-	Crushing				Countersink	$oxed{\!$	1 7	gned/off center	<u> </u>	Positioned V		
	-	Heat Trea				Cut Too Short	L	Mislabe		L	Power Loss/	Surge	Other
	_	Inspectio	· .	Tube		Drawing	<u>_</u>	Misrea				···	
		Marks/Ch			_	Drill Holes	<u> </u>	Off-set					
		Turning S			_	Finish	<u>_</u>	-1	Calibration				
		Wave/Tw	ist in Tub	oe	L_	Fit/Function		Out of :	Sequence				

DART AEROSPACE LTD	Work Order:	109908
Description: Clevis	Part Number:	D3447-7
Inspection Dwg: D3447 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.735	+/-0.010	.739			VERN	P40-12
0.735	+/-0.010	.738			10	(1
Ø1.130	+/-0.030	1, 132			1,	11
2.500	+/-0.010	2,498			1,1	*
1.225	+/-0.010	1,225			K	
0.156	+/-0.010	. 156			11.	11
Ø0.257	+0.005/-0.000	. 257			11	, 1
5.130	+/-0.030	5.112	V		C	1
0.350	+/-0.010	.349	V		А	11
1.56	+/-0.030	1,543	V		ıl	И
R0.130	+/-0.010	. 125	/		Rad G	
0.385	+0.050/-0.000	.407	V		UERU	PUO-12
			_			
					,	

Measured by: 40
9-89

Audited by: Ft. Prototype Approval: N/A

Date: 13/12/2

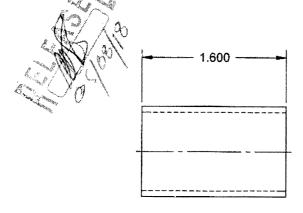
Date: 13/12/2

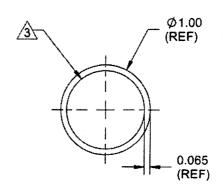
Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.09.19	New Issue	KJ/JLM of	
	·			7,0.7



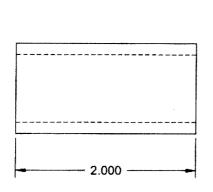
DESIGN DRAW		N BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECK		PRRO	8	D3447	REV. A
05.07.19				BLADE FOLD KIT PARTS	SCALE 1:1
Α	A 05.07.19			NEW ISSUE	

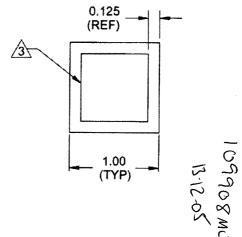




D3447-1 ROUND SPACER

1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)





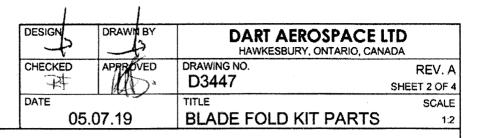
D3447-3 SQUARE SPACER

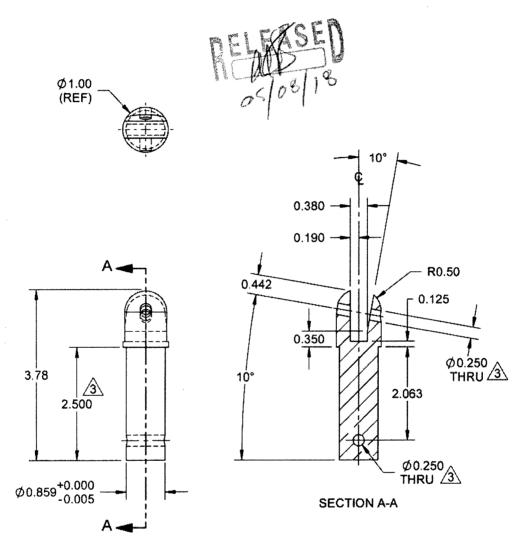
1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

NOTES:

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) MASK INSIDE OF TUBING BEFORE PAINTING.
 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES 7) BREAK ALL SHARP EDGES 0.005 TO 0.010







D3447-5 CLEVIS SUPERSEDES PREMIER P/N B67-43001-99

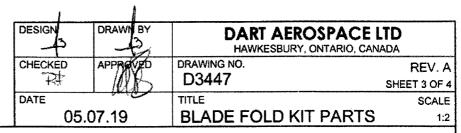
NOTES:

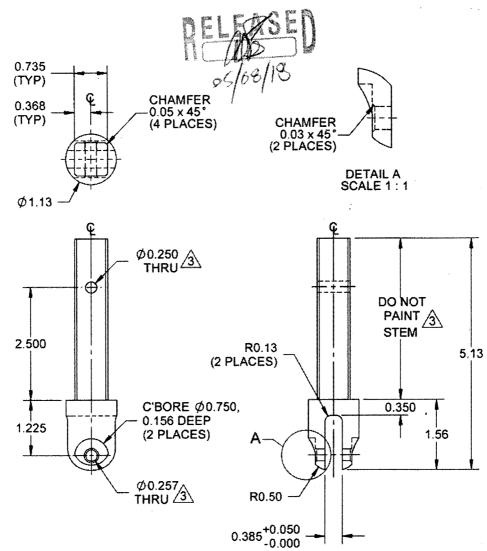
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF. DART SPEC. M606116R1.000)

 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 6) ALL DIMENSIONS ARE IN INCHES
 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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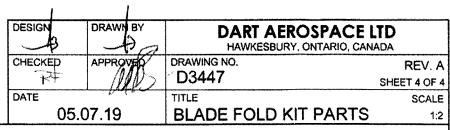
D3447-7 CLEVIS SUPERCEDES PREMIER P/N B67-43001-145/-345

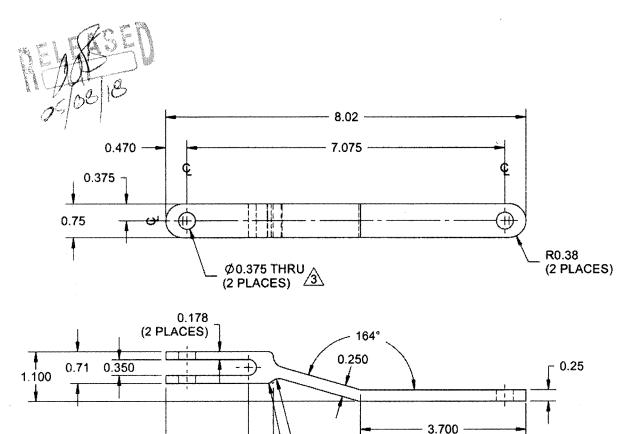
NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.125)
2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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D3447-9 SWING ARM SUPERSEDES PREMIER P/N B67-43001-263

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160)

R_{0.25}

R0.13

(2 PLACES)

(4 PLACES)

- (REF. DART SPEC. M6061T6B)
 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING

- 1.825 -

2.375

(2 PLACES)

- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 6) ALL DIMENSIONS ARE IN INCHES 7) BREAK ALL SHARP EDGES 0.005 TO 0.010